

Date: Tuesday, 12/20/2005 3:21:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 25302B	
Estimate Number : 11099	
P.O. Number : N/A	Part Number : D31862
This Issue : 12/20/2005 S.O. No. : N/A	Drawing Number : D3186 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/20/2005 Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 25301B	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/20/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: 1 Um: Each
Comment : Est Rev:A New Issue 05-11-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000324

05/12/21

Description: D3186-2 Door

SHIP LABEL D0600-146

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

①

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

C506/03/28

①

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

26-04-04

P70

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

26-04-04

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
				See NCR 032				

NOTE: Date & initial all entries

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Process Sheet

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Job Number: 25302B

Part Number: D31862

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

①
06/04/05

Job Completion



U 26-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3186	REV. A SHEET 1 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
A1	04.11.04	NEW 4.5" WIDE UNIDIRECTIONAL	

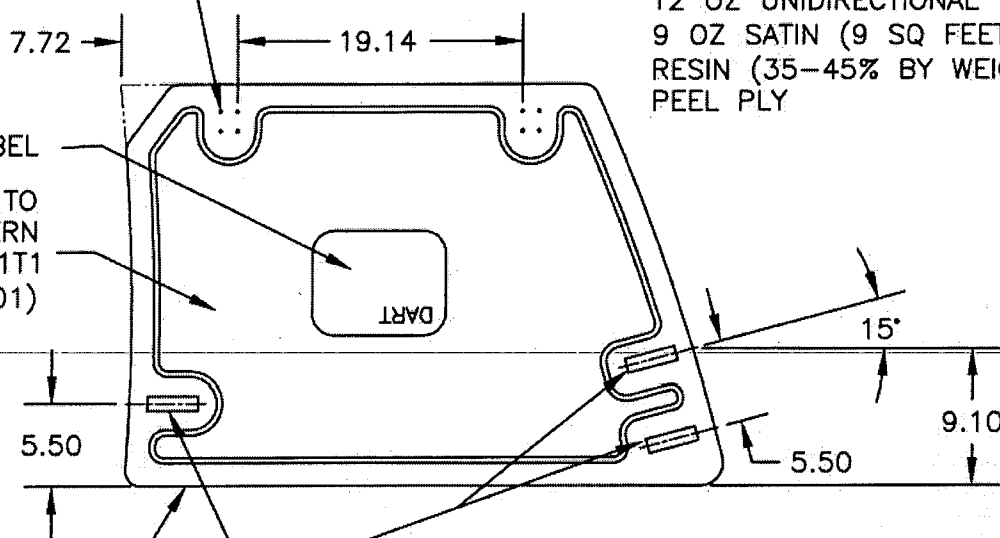
DRILL 8 HOLES $\varnothing 0.171$
PER SCRIBE LINES OF
MOLD DT8005 (REFER
TO DETAIL B ON PAGE 3)

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

D0600-145 LABEL

ROUTER FOAM TO
ROUTER PATTERN
D3186-1T1
(P/N D3186-101)



12 OZ UNIDIRECTIONAL
4.5" WIDE 5" WIDE ALONG
OUTSIDE EDGE

CUT 3 PLACES AS SHOWN IN DETAIL A
ON PAGE 3

RELEASED
#03 04 22

D3186-1

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

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25302B

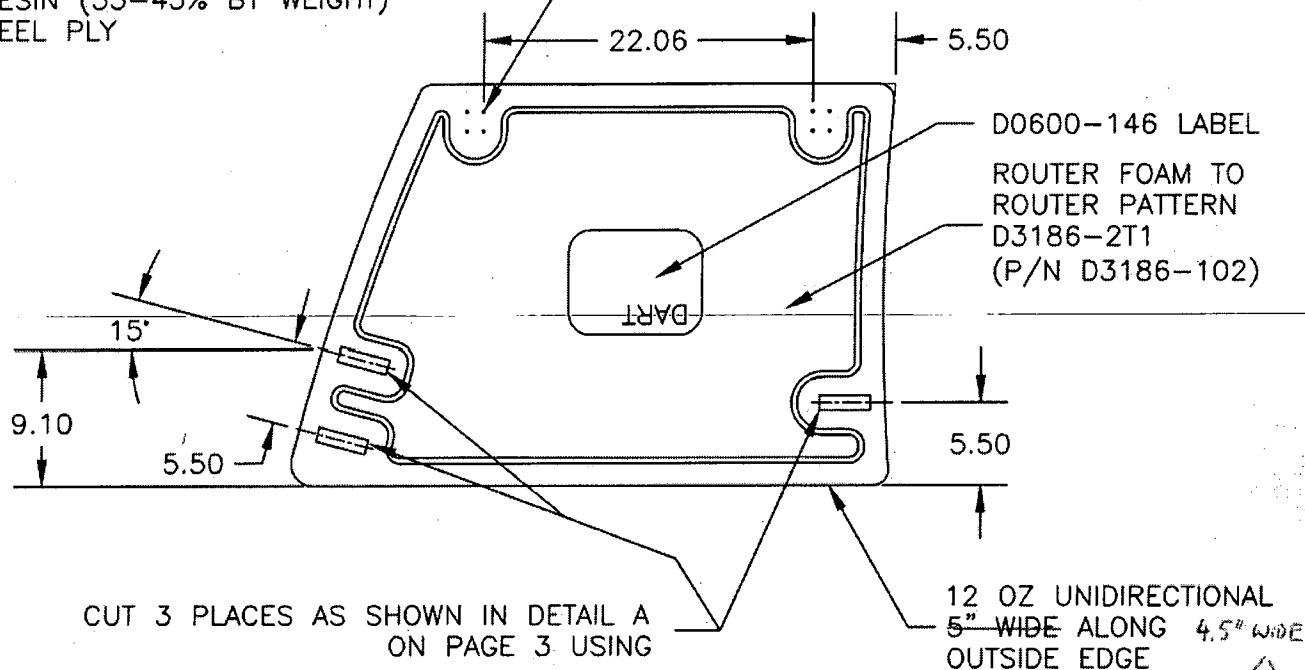


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D3186	REV. A SHEET 2 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

DRILL 8 HOLES $\varnothing 0.171$
PER SCRIBE LINES OF
MOLD DT8006 (REFER
TO DETAIL B ON PAGE 3)



RELEASED
#030422

D3186-2

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

NO 25302B

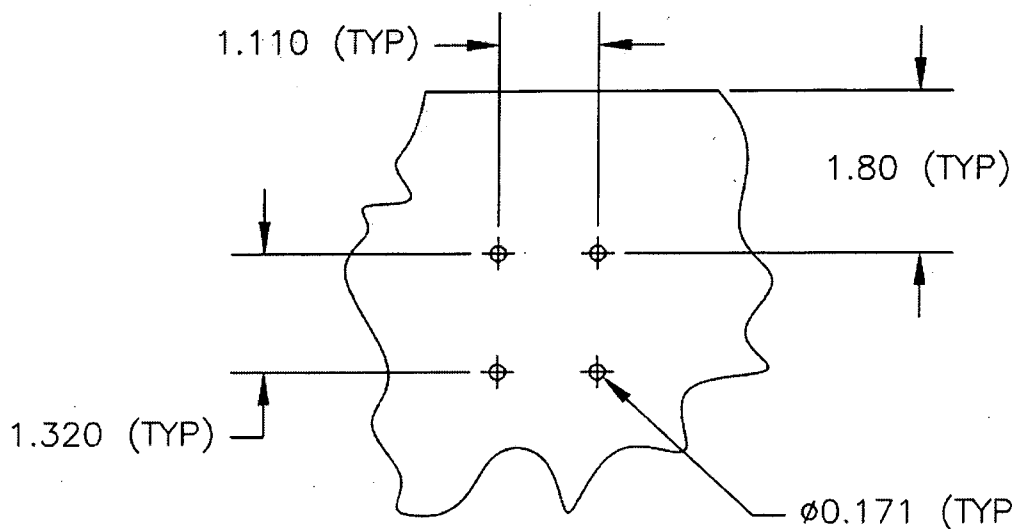
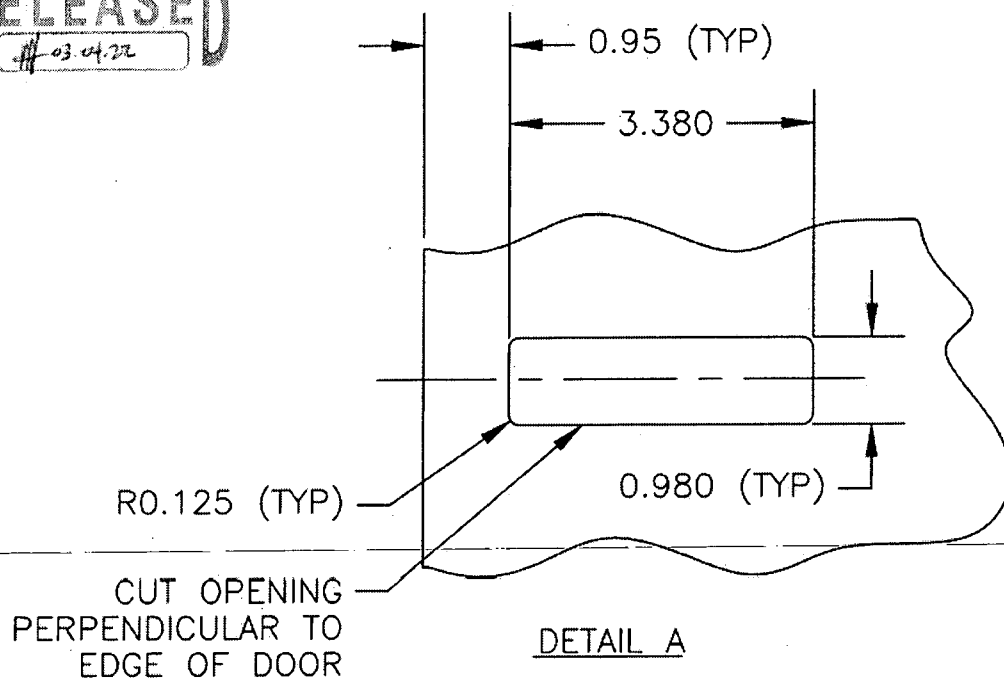
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DESIGN #	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED JP	DRAWING NO. D3186	REV. A SHEET 3 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
03.04.22



DETAIL B

NO. 25302B

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10130
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
21/03/06	21/12/05	4314	Linda Lacelle		PO00000324		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0020	D3188-2 Spacepod Body RH B24307 B25302			
1	0	1	DKC134-0018	D3186-2 Spacepod Door RH B24307 B25302			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: 

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Linda Lacelle

From: Linda Lacelle [llacelle@dartaero.com]
Sent: Tuesday, March 28, 2006 2:24 PM
To: 'Jocelyne Laurin'
Cc: 'shamel@delastek.com'
Subject: RE: RE: SHIPMENT FROM YESTERDAY

ok...here's the scoop:

- for P.O 324 we will use B/N 25300 for the door we received, you will have to supply us the body with the same B/N 25300
- for the D3188-2/86-2 we will use B/N 25302 - the one left to deliver on this P.O 324 - you will have to supply us with the B.N 25301
- for P.O 610 you can only use the B/N's issued on the P.O 25851 and 25852

Thx
Linda

-----Original Message-----

From: Jocelyne Laurin [mailto:jlaurin@delastek.com]
Sent: Tuesday, March 28, 2006 8:56 AM
To: 'Linda Lacelle'
Cc: shamel@delastek.com
Subject: RE : SHIPMENT FROM YESTERDAY

Bonjour Linda,

For p.o. #324 D3186-1, can you please use label #B25851, since the spacepod body LH will have the label #B25851.

As for D3188-2 / D3186-2 - with label 24307, you can use either B26064, B26065 or B25302. Please advise which one you will use.

>From now on, we will mark our W/O and our B/N on the packing slips.

Please note that on your order #610, for the second set of spacepod door and Body LH, we will use label #B25300, since we already used the label #B25851 on po #324.

Thanks and have a nice day.

Jocelyne Laurin
Service à la Clientèle/Customer Service
Tel: 1-819-533-5788 p. 221
Fax: 1-819-533-3494

-----Message d'origine-----

De : Linda Lacelle [mailto:llacelle@dartaero.com]
Envoyé : March 24, 2006 9:18 AM
À : Jocelyne Laurin (E-mail); Mgodin@Delastek.Com (E-mail);
Sheroux@Delastek.Com (E-mail)
Cc : Jason Murdoch (E-mail)
Objet : SHIPMENT FROM YESTERDAY
Importance : Haute

we received a few items yesterday, but were all mixed up...p.o 324 D3186-1 - has a label of 21558 - this is a very old batch, and had been completed in Oct, 2005. There is no w/o marked on your packing slip or invoice...we need to know what labels you have left, so we can figure out what w/o here to attach it to.

D3188-2 / D3186-2 - has a label of 24307 - was completed in Nov., 2005, again no w/o to match from your packing slip, and again need to know what

labels you have left at Delastek, so we can assign the correct internal batch and w/o to it.

D350-604-041...we require you to mark your w/o and our B/N on the packing slips, in order to match the correct process sheets

D206-605-041 ...we require you to mark your w/o and our B/N on the packing slips, in order to atch the correct process sheets.

Please advise asap.

Thanks

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Thanks

Linda

Non-Conformance Report				NCR 032	
Raised by: LINDA LACEY		Source:		Sheet No. ___ of ___	
Non-Conforming Dept./Supplier: DELASTEK				Date: 06-03-29	
Product/Service: space pods D3186 / D3188				Priority: HIGH LOW	
Area of Standard:		Section A			
QSI		Description of Non-Conformance			
QSP		PO 324 calls up B/N's 25299 - 25300 - 25301 - 25302 on P.O			
QSPM		but rec'd labels in door + body 21588			
Documents:		P.O 610 call up B/N's 25851 - 25852 on P.O			
P/O 324 / 610		but rec'd door + body with labels 24307			
Invoice					
W/O					
Batch No. all on same P.O's					
TSR					
Drawing					
Forward to Director, Quality Assurance on completion of this box					
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
Section B		Corrective Action			
		Responsible for Investigation/CA: _____		To be done by: _____	
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	u	Quarantine all until B/N's resolved	JIM	06-03-24	[Signature] 06-03-29
2	u	Advise Delastek of mix up and decide what B/N to allocate associates with P.O	LL / [Signature]	06-03-28	u 06-03-28
3	u	Change with a fine tipped marker correct B/N's on the labels	JIM	06-03-29	[Signature] 06-03-29
4	u	Ensure Delastek knows which B/N's are still come on P.O 324 + 610	u	06-03-29	u 06-03-28
Preventive Action Required: NO YES # _____			Fault Category:		
Section C		Verification of C/A			
		Responsible for Verification of CA: _____			
No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification	
				DQA: _____	
				Date: _____	
QA Purposes only		N/C Closed		Date	